

RETAINER AND ONE-WAY CLUTCH USING THE RETAINER
AND METHOD FOR ASSEMBLING THE ONE-WAY CLUTCH

BACKGROUND OF THE INVENTION

5 [0001] The present invention relates to a retainer and a one-way clutch using the retainer as well as to a method for assembling the one-way clutch.

[0002] Conventionally, there has been a retainer shown in Fig. 6 for use in one-way clutches. This retainer has a first annular portion 81, a second annular portion 82
10 confronting the first annular portion 81, and six pillar portions 85 for connecting the first annular portion 81 and the second annular portion 82 to each other. Then, six pockets 87 are formed between the six pillar portions 85.
15 It is noted that reference numeral 92 denotes a protruding portion to which an unshown coil spring is to be fitted.

[0003] Outer peripheral surfaces of the first and second annular portions 81, 82 are formed into an identical generally regular hexagonal shape. The pillar portions 85
20 are formed by axially extending six edges of the outer peripheral surface of the first annular portion 81 and six edges of the outer peripheral surface of the second annular portion 82. Outer ends of the pillar portions 85 serve as edges 90 of the regular polyhedron.

[0004] The outer peripheral surfaces having a generally regular hexagonal shape in its cross section of the two annular portions 81, 82 and the outer peripheral surfaces of the pillar portions 85, upon assembling of a one-way clutch, are to be engaged with an inner circumferential cam surface of an unshown outer ring of the one-way clutch having a generally regular hexagonal shape in its cross section. Also, the edges 90 axially extending overall between outer ends of the two annular portions 81, 82, upon assembling of the one-way clutch, are to be engaged with the vertices of the inner circumferential cam surface of the outer ring having a generally regular hexagonal shape in its cross section. The edges 90 serve as engagement portions for blocking the retainer from rotating peripherally relative to the outer ring.

[0005] The retainer shown in Fig. 6 is assembled to the one-way clutch as follows.

[0006] First, an unshown roller as a wedge member is placed at each pocket 87 of the retainer, and an unshown coil spring fitted to the protruding portion 92 is placed between pillar portion 85 and roller in the retainer. With the rollers biased to the pillar portions of the retainer by the coil springs, a retainer assembly is made up.

[0007] Next, while the vertices of the inner circumferential cam surface of the unshown outer ring of the

one-way clutch, and the edges 90 of the retainer, are set in phase with each other, end faces of the rollers are brought into contact with inside end faces of an unshown inner ring and the outer ring between the inner circumferential cam surface of the outer ring and an outer circumferential cylindrical surface of the inner ring. Then, in this state, a roller present at a position which is in phase with a wedge position of a narrow radial distance between the outer and inner rings is moved peripherally to a position which is in phase with a clearance-fit position located between the inner circumferential cam surface of the outer ring and the outer circumferential surface of the inner ring by exclusive-use equipment.

[0008] Finally, with the roller located at a position which is in phase with the clearance-fit position, the retainer assembly is pushed axially to between the inner circumferential cam surface of the outer ring and the outer circumferential surface of the inner ring of the one-way clutch so that the roller is positioned between the inner circumferential cam surface of the outer ring and the outer circumferential surface of the inner ring. Thus, the assembling of the one-way clutch is completed.

[0009] Another retainer to be used for one-way clutches is shown in Fig. 3 of JP 2001-141037 A.

[0010] This retainer has an inner peripheral surface shaped into a regular octagon and an outer peripheral cylindrical surface, and is otherwise essentially similar to the retainer shown in Fig. 6.

5 [0011] However, with the use of the prior art retainer shown in Fig. 6, there is a problem that the assembling of the one-way clutch involves the need for exclusive-use equipment for moving the roller, which is present at a position in phase with an engagement position where the
10 radial distance between outer and inner rings is narrower than the diameter of the roller, up to a position in phase with a clearance-fit position.

[0012] Also, because of a need for setting the outer ring, the inner ring and the retainer assembly to the
15 exclusive-use equipment, there is another problem that man-hours required for the assembling of the one-way clutch is increased, which leads to an increase in the assembling cost of the one-way clutch.

20 SUMMARY OF THE INVENTION

[0013] Accordingly, an object of the present invention is to provide a retainer which allows a one-way clutch to be assembled with simplicity and low cost without using any exclusive-use equipment, as well as a one-way clutch using

the retainer, and also provide a method for assembling the one-way clutch.

[0014] In order to achieve the above object, in a first aspect of the present invention, there is provided a
5 retainer comprising:

two annular portions; and

a plurality of pillar portions for connecting the two annular portions to each other to define a plurality of pockets in combination with the annular portions, wherein

10 an engagement portion to be engaged with an outer ring is formed on an outer periphery of at least one annular portion of the two annular portions and part of each of the pillar portions located on the annular portion side to block the retainer from rotating circumferentially
15 relative to the outer ring,

a non-engagement outer peripheral surface which is not engaged with the outer ring is formed on an outer peripheral surface of the other annular portion and part of each of the pillar portions located on the annular portion
20 side, and

the non-engagement outer peripheral surface is located inside a circle smaller by a specified size than a circumcircle of the engagement portion.

[0015] In assembling of a one-way clutch with the
25 retainer according to the first aspect of the invention,

first, rollers are placed in the pockets of the retainer and moreover the biasing members are placed between the pillar portions of the retainer and the rollers, by which a retainer assembly is formed. Next, the non-engagement outer peripheral surface of the retainer of the retainer assembly is inserted axially in an non-engagement state to between an inner peripheral engagement surface of the outer ring and an outer peripheral surface of an inner ring of the one-way clutch such that part of the roller is placed at a position where the roller is clearance-fitted between the inner peripheral engagement surface of the outer ring and the outer peripheral surface of the inner ring of the one-way clutch. Next, the retainer assembly is rotated until a peripheral position of the engagement portion of the retainer and a peripheral position of an engagement portion of the outer ring becomes coincident with each other, and thereafter the retainer assembly is inserted axially all the way to the end between the inner peripheral engagement surface of the outer ring and the outer peripheral surface of the inner ring so that the engagement portion of the retainer and the engagement portion of the outer ring are engaged with each other. Thus, the assembly of the one-way clutch is completed.

[0016] According to the retainer of the first aspect of

the present invention, since a non-engagement outer

peripheral surface positioned inside a circle smaller by a specified size than the circumcircle of the engagement portions of the retainer is provided on the outer peripheral surface of the other annular portion and part of each of the pillar portions positioned on the annular portion side, part of the roller can be inserted beforehand at a clearance-fit position between the inner peripheral engagement surface of the outer ring and the outer peripheral surface of the inner ring before making the engagement portion of the retainer and the engagement portion of the outer ring coincident with each other in peripheral position and inserting the retainer assembly to between the inner peripheral engagement surface of the outer ring and the outer peripheral surface of the inner ring of the one-way clutch.

[0017] Therefore, because there is no need for moving the rollers located near wedge positions to near the clearance-fit positions by using some exclusive-use equipment, which would be needed in the conventional assembling method for one-way clutches, the one-way clutch can be assembled with simplicity and low cost and without involving any exclusive-use equipment with the use of the retainer of the first aspect of the invention.

[0018] In one embodiment, the non-engagement outer peripheral surface is a cylindrical surface.

[0019] According to this embodiment, since the non-engagement outer peripheral surface is a cylindrical surface, the non-engagement outer peripheral surface can be machined with simplicity, so that the retainer can be manufactured with low cost.

[0020] In a second aspect of the invention, there is provided a retainer comprising:

two annular portions; and

a plurality of pillar portions for connecting the two annular portions to each other to define a plurality of pockets in combination with the annular portions, wherein

an engagement portion to be engaged with an inner ring is formed on an inner periphery of at least one annular portion of the two annular portions and part of each of the pillar portions located on the annular portion side to block the retainer from rotating circumferentially relative to the inner ring,

a non-engagement inner peripheral surface which is not engaged with the inner ring is formed on an inner peripheral surface of the other annular portion and part of each of the pillar portions located on the annular portion side, and

the non-engagement inner peripheral surface is located outside a circle larger by a specified size than a circumcircle of the engagement portion.

[0021] In assembling of a one-way clutch with the retainer according to the second aspect of the invention, first, rollers are placed in the pockets of the retainer and moreover the biasing members are placed between the pillar
5 portions of the retainer and the rollers, by which a retainer assembly is formed. Next, the non-engagement inner peripheral surface of the retainer of the retainer assembly is inserted axially in a non-engagement state to between an inner peripheral surface of an outer ring and an outer
10 peripheral engagement surface of the inner ring of the one-way clutch such that part of the roller is placed at a position where the roller is clearance-fitted between the inner peripheral surface of the outer ring and the outer peripheral engagement surface of the inner ring of the one-
15 way clutch. Finally, the retainer assembly is rotated until a peripheral position of the engagement portion of the retainer and a peripheral position of an engagement portion of the inner ring becomes coincident with each other, and thereafter the retainer assembly is inserted
20 axially all the way to the end between the inner peripheral surface of the outer ring and the outer peripheral engagement surface of the inner ring so that the engagement portion of the retainer and the engagement portion of the inner ring are engaged with each other. Thus, the assembly
25 of the one-way clutch is completed.

[0022] According to the retainer of the second aspect of the present invention, since a non-engagement inner peripheral surface positioned outside a circle larger by a specified size than the circumcircle of the engagement portions is provided on the inner peripheral surface of the other annular portion and part of the pillar portions positioned on the annular portion side, part of the roller can be inserted beforehand at a clearance-fit position between the inner peripheral surface of the outer ring and the outer peripheral engagement surface of the inner ring before making the engagement portion of the retainer and the engagement portion of the inner ring coincident with each other in peripheral position and inserting the retainer assembly to between the inner peripheral surface of the outer ring and the outer peripheral engagement surface of the inner ring of the one-way clutch. Therefore, because there is no need for moving the rollers located near wedge positions to near the clearance-fit positions by using some exclusive-use equipment, which would be needed in the conventional assembling method for one-way clutches, the one-way clutch can be assembled with simplicity and low cost and without involving any exclusive-use equipment with the use of the retainer of the second aspect of the invention.

[0023] In one embodiment, the non-engagement inner peripheral surface is a cylindrical surface.

[0024] According to this embodiment, since the non-engagement inner peripheral surface is a cylindrical surface, the non-engagement inner peripheral surface can be machined with simplicity, so that the retainer can be manufactured with low cost.

[0025] Also in the first aspect of the invention, there is provided a one-way clutch comprising:

10 an outer ring having an inner peripheral engagement surface which is a cam surface having a generally polygonal shape in its cross section;

an inner ring having an outer peripheral surface which is a circumferential surface;

15 the retainer of the first aspect of the invention placed between the inner peripheral engagement surface and the outer peripheral surface;

rollers placed in the pockets of the retainer; and

20 biasing members for respectively biasing the rollers in one circumferential direction.

[0026] According to the one-way clutch of the first aspect of the invention, since the retainer of the first aspect of the invention is included, the retainer assembly in which the rollers are placed in the pockets of the

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retainer and in which the biasing members are placed between the pillar portions of the retainer and the rollers can be inserted to between the outer peripheral surface of the inner ring and the inner peripheral engagement surface of the outer ring with simplicity and low cost without using any exclusive-use equipment. Therefore, the one-way clutch can be assembled with simplicity and low cost.

[0027] In a second aspect of the present invention, there is provided a one-way clutch comprising:

10 an outer ring having an inner peripheral surface which is a circumferential surface;

an inner ring having an outer peripheral engagement surface which is a cam surface having a generally polygonal shape in its cross section;

15 the retainer of the second aspect of the invention placed between the inner peripheral surface and the outer peripheral engagement surface;

rollers placed in the pockets of the retainer;
and

20 biasing members for respectively biasing the rollers in one circumferential direction.

[0028] According to the one-way clutch of the second aspect of the invention, since the retainer according to the second aspect of the invention is included, the retainer assembly in which the rollers are placed in the

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pockets of the retainer and the biasing members are placed between the pillar portions of the retainer and the rollers can be inserted to between the outer peripheral engagement surface of the inner ring and the inner peripheral surface of the outer ring with simplicity and low cost without using any exclusive-use equipment. Therefore, the one-way clutch can be assembled with simplicity and low cost.

[0029] Also in the first aspect of the invention, there is provided a method for assembling a one-way clutch comprising:

forming a retainer assembly by respectively placing rollers in the pockets of the retainer of the first aspect of the invention and placing biasing members such that each biasing member is disposed between the pillar portion of the retainer and the roller corresponding to the pillar portion;

inserting the non-engagement outer peripheral surface of the retainer of the retainer assembly axially in an non-engagement state to between an inner peripheral engagement surface of an outer ring and an outer peripheral surface of an inner ring of the one-way clutch so that the roller of the retainer assembly is disposed in a position where the roller is clearance-fitted between the inner peripheral engagement surface of the outer ring of the one-way clutch, which is a cam surface having a generally

polygonal shape in its cross section, and the outer peripheral surface, which is a circumferential surface of the inner ring; and

5 rotating the retainer assembly such that the engagement portion of the retainer becomes coincident in peripheral position with the engagement portion of the outer ring and thereafter further inserting the retainer assembly axially between the outer peripheral surface of the inner ring and the inner peripheral engagement surface
10 of the outer ring such that the engagement portion of the retainer and the engagement portion of the outer ring are engaged with each other.

[0030] According to the method for assembling the one-way clutch of the first aspect of the invention, the one-way clutch can be assembled with simplicity and low cost
15 without using any exclusive-use equipment.

[0031] Also in the second aspect of the invention, there is provided a method for assembling a one-way clutch comprising:

20 forming a retainer assembly by respectively placing rollers in the pockets of the retainer of the second aspect of the invention and placing biasing members such that each biasing member is disposed between the pillar portion of the retainer and the roller corresponding
25 to the pillar portion;

inserting the non-engagement inner peripheral surface of the retainer of the retainer assembly axially in an non-engagement state to between an inner peripheral surface of an outer ring and an outer peripheral engagement surface of an inner ring of the one-way clutch so that the roller of the retainer assembly is disposed in a position where the roller is clearance-fitted between the inner peripheral surface, which is a circumferential surface of the outer ring, and the outer peripheral engagement surface, which is a cam surface of the inner ring having a generally polygonal shape in its cross section, of the inner ring of the one-way clutch; and

rotating the retainer assembly such that the engagement portion of the retainer becomes coincident in peripheral position with the engagement portion of the inner ring and thereafter further inserting the retainer assembly axially between the outer peripheral engagement surface of the inner ring and the inner peripheral surface of the outer ring such that the engagement portion of the retainer and the engagement portion of the inner ring are engaged with each other.

[0032] According to the method for assembling the one-way clutch of the second aspect of the invention, the one-way clutch can be assembled with simplicity and low cost without using any exclusive-use equipment.

[0033] According to the retainer of the first aspect of the invention, a non-engagement outer peripheral surface positioned inside a circle smaller by a specified size than the circumcircle of the engagement portions of the retainer is provided on the outer peripheral surface of the other annular portion and part of each of the pillar portions positioned on the annular portion side. Therefore, part of the roller of the retainer assembly wherein the retainer assembly is formed by setting the rollers and the biasing members in the retainer can be inserted beforehand at clearance-fit positions between the inner peripheral engagement surface of the outer ring and the outer peripheral surface of the inner ring before making the engagement portion of the retainer and the engagement portion of the outer ring coincident with each other in peripheral position and inserting the retainer assembly to between the inner peripheral engagement surface of the outer ring and the outer peripheral surface of the inner ring of the one-way clutch. Therefore, because there is no need for moving the rollers located near wedge positions to near the clearance-fit positions by using some exclusive-use equipment, which would be needed in the one-way clutch assembling method using conventional retainers, the one-way clutch can be assembled with simplicity and low cost.

[0034] In the retainer of one embodiment, since the non-engagement outer peripheral surface is a cylindrical surface, the non-engagement outer peripheral surface can be machined with simplicity, so that the retainer can be manufactured with low cost.

[0035] According to the retainer of the second aspect of the invention, a non-engagement inner peripheral surface positioned outside a circle larger by a specified size than the circumcircle of the engagement portions is provided on the inner peripheral surface of the other annular portion and part of each of the pillar portions positioned on the annular portion side. Therefore, part of the rollers of the retainer assembly wherein the retainer assembly is formed by setting the rollers and the biasing member in the retainer can be inserted beforehand at clearance-fit positions between the inner peripheral surface of the outer ring and the outer peripheral engagement surface of the inner ring before making the engagement portion of the retainer and the engagement portion of the inner ring coincident with each other in peripheral position and inserting the retainer assembly to between the inner peripheral surface of the outer ring and the outer peripheral engagement surface of the inner ring of the one-way clutch. Therefore, because there is no need for moving the rollers located near wedge positions to near the

clearance-fit positions by using some exclusive-use equipment, which would be needed in the one-way clutch assembling method using conventional retainers, the one-way clutch can be assembled with simplicity and low cost.

5 [0036] In the retainer of one embodiment, since the non-engagement inner peripheral surface is a cylindrical surface, the non-engagement inner peripheral surface can be machined with simplicity, so that the retainer can be manufactured with low cost.

10 [0037] According to the one-way clutch of the first aspect of the invention, since the retainer of the first aspect of the invention is included, the retainer assembly can be inserted to between the inner peripheral engagement surface of the outer ring and the outer peripheral surface
15 of the inner ring with simplicity without using any exclusive-use equipment. Thus, the one-way clutch can be assembled with simplicity and low cost.

[0038] Further, according to the one-way clutch of the second aspect of the invention, since the retainer of the
20 second aspect of the invention is included, the retainer assembly can be inserted to between the inner peripheral surface of the outer ring and the outer peripheral engagement surface of the inner ring with simplicity without using any exclusive-use equipment. Thus, the one-
25 way clutch can be assembled with simplicity and low cost.

[0039] Further, according to the method for assembling the one-way clutch of the first and second aspects of the invention, the one-way clutch can be assembled with simplicity and low cost without using any exclusive-use equipment.

BRIEF DESCRIPTION OF THE DRAWINGS

[0040] Fig. 1 is a view showing an embodiment of the retainer in a first aspect of the present invention;

Fig. 2 is a view showing a retainer assembly including rollers and coil springs set on the retainer of Fig. 1;

Fig. 3 is a view showing an outer ring and an inner ring by which a space to which the retainer assembly of Fig. 2 is to be fitted is defined;

Fig. 4 is a front view showing an embodiment of the retainer in a second aspect of the present invention;

Fig. 5 is a sectional view of the retainer of Fig. 4 along its axial direction; and

Fig. 6 is a view showing a retainer according to a prior art.

DETAILED DESCRIPTION OF THE INVENTION

[0041] Hereinbelow, the present invention will be described in detail by embodiments thereof illustrated in the accompanying drawings.

[0042] Fig. 1 shows a retainer for use with a one-way
5 clutch according to an embodiment of the retainer in a first aspect of the invention. The retainer includes an annular portion 2, an annular portion 3 confronting the annular portion 2, and six pillar portions 4 for connecting the annular portion 2 and the annular portion 3 to each other.
10 Six pockets 7 are formed between the six pillar portions 4. It is noted that reference numeral 8 denotes a protruding portion to which an unshown coil spring as an example of biasing member is to be fitted.

[0043] The annular portion 2 has an outer peripheral
15 surface 12 having a generally regular hexagonal shape in its cross section and a cylindrical inner peripheral surface. The annular portion 3 has an outer circumferential cylindrical surface 13 smaller in radial size than a circumference of edges 9 of the outer peripheral surface 12
20 of the annular portion 2 having a generally regular hexagonal shape in its cross section, and a cylindrical inner peripheral surface equal in inner diameter to the cylindrical inner peripheral surface of the annular portion 2.

[0044] Each of the six pillar portions 4 has a triangular-prismatic portion 14 which is formed by axially extending an edge 9 of the annular portion 2 and which is a larger axial length, and an axially smaller-sized portion 15
5 which adjoins the triangular-prismatic portion 14 and which has an outer circumferential cylindrical surface 17 formed by axially extending part of the annular portion 3.

[0045] Each of the edges 9 ranging from an axial outer end of the annular portion 2 in the outer peripheral surface
10 of the annular portion 2 to the axially larger triangular-prismatic portion 14 of the pillar portion 4 serves as an engagement portion of the retainer. In more detail, the edges 9, upon assembling of the one-way clutch, are engaged with the engagement portions of the outer ring of the
15 unshown one-way clutch, thereby blocking the retainer from peripherally rotating relative to the outer ring.

[0046] Meanwhile, the outer circumferential cylindrical surface 13, 17 extending from an outer end of the annular portion 3 to the axially smaller-sized portions 15 of the
20 pillar portions 4 serves as a non-engagement outer peripheral surface positioned inside a circle which is smaller by a specified size than the circumcircle of the edges 9 serving as engagement portions.

[0047] Fig. 2 shows a retainer assembly formed by using
25 the retainer of the embodiment shown in Fig. 1.

[0048] This retainer assembly is so formed that a coil spring 21 as an example of the biasing member is placed at each protruding portion 8 and moreover a roller 22 is placed at each pocket 7 of the retainer. In this retainer assembly, the coil spring 21 biases the roller 22 up to the pillar portion 4. Also, part of the roller 22 is exposed from a clearance part of the pocket 7 peripherally corresponding to the axially smaller-sized portions 15 and 15.

10 [0049] Fig. 3 shows an outer ring 31 and an inner ring 35 which define a space to which the retainer assembly shown in Fig. 2 is to be fitted.

[0050] The outer ring 31 has an inner peripheral cam surface 37 having a generally regular hexagonal shape in its cross section as an example of an inner peripheral engagement surface which is to be engaged with the outer peripheral surface 12 of the annular portion 2 having a generally regular hexagonal shape in its cross section and with an outer peripheral surface of the axially larger-sized triangular-prismatic portion 14 in the pillar portion 4. The inner ring 35, on the other hand, has an outer peripheral cylindrical surface 38 serving as an outer peripheral surface to which the inner peripheral cylindrical surfaces of the annular portions 2, 3 are to be fitted.

[0051] Vertices of the inner peripheral cam surface 37 of the outer ring 31 each having a generally regular hexagonal shape in its cross section serve as engagement portions. The vertices of the inner peripheral cam surface 37, upon assembling of the one-way clutch, are to be engaged with the edges 9 serving as engagement portions of the retainer, thereby immobilizing the retainer relative to the outer ring 31.

[0052] Referring to Figs. 2 and 3, the method for assembling the one-way clutch according to an embodiment of the present invention is described below.

[0053] First, the roller 22 placed at the pocket 7 is set to confront the position where the roller 22 of the retainer assembly shown in Fig. 2 is clearance-fitted between the inner peripheral cam surface 37 of the outer ring 31 and the outer peripheral cylindrical surface 38 of the inner ring 35 shown in Fig. 3. Then, in this state, the outer peripheral cylindrical surfaces 13, 17, which are non-engagement outer peripheral surfaces of the retainer assembly, is inserted axially in a non-engagement state in a direction indicated by arrow A in Figs. 2 and 3 (arrows A in Figs. 2 and 3 are assumed as the same one) between the inner peripheral cam surface 37 of the outer ring 31 and the outer peripheral cylindrical surface 38 of the inner ring 35. In this way, part of the roller 22 exposed from between the axially

smaller-sized portions 15 outside the pockets 7 is set to a position where the roller 22 of the retainer assembly shown in Fig. 2 is clearance-fitted between the inner peripheral cam surface 37 of the outer ring 31 and the outer peripheral cylindrical surface 38 of the inner ring 35 shown in Fig. 3.

[0054] Next, the retainer assembly is rotated in a direction shown by arrow B in Fig. 2 so that the edges 9 of the retainer of the retainer assembly shown in Fig. 2 and the vertices of the inner peripheral cam surface 37 of the outer ring 31 become coincident with each other in peripheral position. Thereafter, the retainer assembly is inserted between the inner peripheral cam surface 37 of the outer ring 31 and the outer peripheral cylindrical surface 38 of the inner ring 35 all the way to the end axially in the direction shown by arrow A in Figs. 2 and 3. Thus, the edges 9 of the retainer and the vertices of the inner peripheral cam surface 37 of the outer ring 31 are engaged with each other, respectively, by which the assembling of the one-way clutch according to an embodiment of the invention is completed.

[0055] According to the retainer of this embodiment, since the outer circumferential cylindrical surface 13, 17, which is positioned inside a circle which is smaller by a specified size than the circumcircle of the edges 9 serving

as engagement portions of the retainer, is formed so as to range from the axial end portion of the annular portion 3 to part of the pillar portions 4, part of each roller 22 exposed from a portion of the pockets 7 between the outer peripheral cylindrical surfaces 17 of the pillar portions 4, which are portions of the non-engagement outer peripheral surfaces, can be inserted to clearance-fit positions between the inner peripheral cam surface 37 of the outer ring 31 and the outer peripheral cylindrical surface 38 of the inner ring 35 at the beginning of the assembly process for assembling the retainer to the one-way clutch.

[0056] Therefore, the one-way clutch can be assembled with simplicity and low cost and without involving any exclusive-use equipment because there is no need for moving the rollers located near wedge positions to near the clearance-fit positions by using some exclusive-use equipment, which would be needed in the conventional assembling method for one-way clutches.

[0057] Also, according to the retainer of the embodiment, since the non-engagement outer peripheral surface is provided by the outer peripheral cylindrical surface 13, 17, the non-engagement outer peripheral surface can be machined easily, so that the retainer can be manufactured with low cost.

[0058] In addition, in the retainer of this embodiment, the non-engagement outer peripheral surface ranging from the outer end of the annular portion 3 to the axially smaller-sized portions 15 of the pillar portions 4, i.e.,
5 the non-engagement outer peripheral surface that is formed in the outer peripheral surfaces of the annular portion 3 and part of the pillar portions 4 located on the annular portion 3 side and that is not engaged with the outer ring 31 is formed by the outer peripheral cylindrical surfaces
10 13, 17 that are equal in diameter to each other and that are located inside a circle which is smaller by a specified size than a circumcircle of the edges 9 serving as the engagement portions of the retainer.

[0059] However, the non-engagement outer peripheral
15 surface ranging from the outer end of one annular portion of the two to the axially smaller-sized portion of the pillar portion may also be formed by, for example, an outer peripheral surface having a polygonal or other shape in its cross section and located inside a circle which is smaller
20 by a specified size than the circumcircle of the edges serving as the engagement portions of the retainer.

[0060] Also, a plurality of outer peripheral surfaces of different diameters which are located inside a circle smaller by a specified size than the circumcircle of the
25 edges serving as the engagement portions of the retainer

and which adjoin each other via a step portion may be formed at portions each ranging from the outer end of one annular portion of the two to axially smaller-sized parts of the pillar portions.

5 [0061] In short, the portion ranging from the outer end of the annular portion to the axially extending parts of the pillar portions may be provided in any shape only if the portion ranging from the outer end of the annular portion to the axially extending parts of the pillar
10 portions is entirely included inside the circle smaller by a specified size than the circumcircle of the engagement portions.

[0062] In this embodiment, the edges 9 that are the engagement portions of the retainer are formed in the
15 portions each ranging from the axial outer end of the annular portion 2 in the outer peripheral surface of the annular portion 2 to part of the pillar portions 4. However, for the present invention, the engagement portions of the retainer may be formed at at least one of either
20 annular portion and part of the pillar portions.

[0063] Fig. 4 is a front view of an embodiment of the retainer in a second aspect of the invention. Fig. 5 is a axial sectional view of the retainer of this embodiment.

[0064] The retainer, as shown in Figs. 4 and 5, includes
25 an annular portion 50, an annular portion 51 confronting

the annular portion 50, and six pillar portions 47 for axially connecting the two annular portions 50, 51 to each other. Six pockets 48 for placement of rollers are formed between the six pillar portions 47.

5 [0065] The annular portion 51 and most part of each pillar portion 47 which adjoins the annular portion 51 have an inner peripheral surface 41 having a generally regular hexagonal shape in its cross section and a cylindrical outer peripheral surface 45. The six vertices 46 of the
10 inner peripheral surface 41 having a generally regular hexagonal shape in its cross section are to be engaged with edges of an inner peripheral surface of an inner ring having a generally regular hexagonal shape in its cross section in an unshown one-way clutch. The six vertices 46
15 of the inner peripheral surface 41 having the generally regular hexagonal shape in its cross section serve as engagement portions. The edges of the outer peripheral surface of the inner ring having a generally regular hexagonal shape in its cross section also serve as
20 engagement portions.

 [0066] Further, the retainer, as shown in Figs. 4 and 5, has an inner circumferential cylindrical surface 49 serving as an non-engagement inner peripheral surface which ranges from an outer end of the annular portion 50 to an axially
25 extend part of the pillar portion 47 and which is located

outside a circle larger by a specified size than the circumcircle of the vertices 46 serving as the engagement portions. In other words, the retainer has a non-engagement inner peripheral surface 49 which is formed in an inner circumferential surface of the annular portion 50 and part of a pillar portion 47 located on the annular portion 50 side and which is not engaged with the inner ring.

[0067] According to the retainer of this embodiment, the retainer includes the inner circumferential cylindrical surface 49 that ranges from the outer end of the annular portion 50 to axially extending parts of the pillar portions 47 and that is located outside a circle larger by a specified size than the circumcircle of the vertices 46 serving as engagement portions. As a result of this, part of each roller (not shown) exposed from between the inner peripheral cylindrical surfaces 49 of the pillar portions 47 of the pockets 48 in the retainer assembly formed by placing an unshown roller and a coil spring at each pocket 48 of the retainer can be inserted beforehand at a clearance-fit position between the inner peripheral cylindrical surface of the outer ring and the outer peripheral cam surface of the inner ring at the beginning of assembly for assembling the retainer assembly to between the inner ring and the outer ring. Then, after that, by

making the vertices 46 of the retainer in the retainer assembly and the engagement portions (not shown) of the inner ring set to a coincident peripheral position, the retainer assembly can be inserted axially to between the
5 inner peripheral cylindrical surface of the outer ring and the outer peripheral cam surface of the inner ring in the one-way clutch.

[0068] Therefore, the one-way clutch can be assembled with simplicity and low cost and without involving any
10 exclusive-use equipment because there is no need for moving the rollers located near wedge positions to near the clearance-fit positions by using some exclusive-use equipment, which would be needed in the conventional assembling method for one-way clutches.

[0069] Also, according to the retainer of the embodiment, since the non-engagement inner peripheral surface is provided by the cylindrical inner peripheral surface 49, the non-engagement inner peripheral surface can be machined easily, so that the retainer can be
15 manufactured with low cost.
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[0070] In addition, in the retainer of this embodiment, the non-engagement inner peripheral surface is formed by one inner peripheral cylindrical surface 49 which ranges from the outer end of the annular portion 50 to the axially
25 extending portion of each pillar portion 47. However, the

non-engagement inner peripheral surface may also be formed by one inner peripheral surface which ranges from the outer end of one annular portion of the two to an axially smaller-sized portion of each pillar portion and which has a generally polygonal shape in its cross section or the like. Also, a plurality of cylindrical surfaces of different diameters which are located outside a circle larger by a specified size than the circumcircle of the vertices serving as the engagement portions of the retainer may be formed at portions ranging from the outer end of one annular portion of the two to axially extending parts of the pillar portions. The portion ranging from the outer end of one annular portion of the two to the axially extending parts of the pillar portions may be provided in any shape only if the shape includes the entirety of the portion ranging from the outer end of one annular portion of the two to the axially extending parts of the pillar portions.

[0071] Further, in the retainer of this embodiment, the six vertices 46 of the inner peripheral surface 41 serving as engagement portions of the retainer are formed in the portions each ranging from the axial outer end of the annular portion 51 in the outer peripheral surface of the annular portion 51 to part of the pillar portion 47. However, for the present invention, the engagement portions

of the retainer may be formed at at least one of either annular portion of the two and part of the pillar portions.

[0072] Still also, rollers are used in all of the foregoing embodiments. However, for the present invention,

5 there is used any member to have the function as an engagement element, and therefore there may be provided sprags or the like. The biasing member may be provided by a plate spring.